

Date: Wednesday, 29/04/2009 3:07:47 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : INNER FWD SADDLE
<b>Job Number</b> : 47631	
<b>Estimate Number</b> : 11079	
<b>P.O. Number</b> :	<b>Part Number</b> : D5953
<b>This Issue</b> : 29/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D5953 REVB
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 46902	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/05/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : JLD 09.04.29	
<b>Comment</b> : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:f ecn 826 06.12.06 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101007	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 D6101-007(7075-T7351)  
 Size 2.50" x 7.50" X 8.25" (Grain along 7.50")  
 Batch: 46412 X4

J.L 09/05/04

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Pto →

**Comment:** HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5953, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr &amp; Tumble

H.A

09/05/05

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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(4)

**Comment:** INSPECT ALL DIM TO DIM SHEET

H.A

09/05/05

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

H.A

09/05/11

(4)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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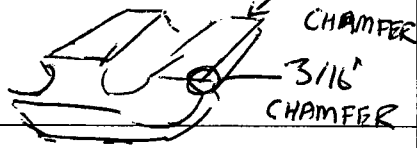
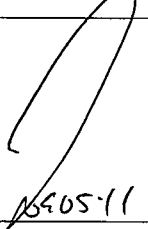
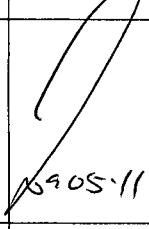
**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

H.A 09-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5953 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>47631</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/05/05</u>	<u>2.0</u>	- chanfer is .090" instead of .063 (+/- .010) - chanfer in both corners in back of saddle are oversized due to wrong setup from previous shift The tool (1" end mill) was not long enough so it touched the saddle with the holder Also 3/16" CHAMFER IN CORNERS P.C.: process NCR	<u>CP</u> <u>09.05.11</u> <u>09/05/05</u>	Acceptable 	<u>H.A</u> <u>09/05/05</u>		<u>CP</u> <u>09.05.11</u> <u>PC</u> <u>09/05/05</u>	

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:07:47 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER FWD SADDLE

Job Number: 47631

Part Number: D5953

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:05

OVEN TEMPERATURE:

320°

FINISH TIME:

9:35

FL 09/05/12

4

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



res



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-12

x4

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 430

88 09/05/12 (x4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	47431
<b>Description:</b> Inner Fwd Saddle		<b>Part Number:</b>	D5953
<b>Inspection Dwg:</b> D5953		<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.320	0.320	0.320	0.320		
H	1.522	1.532		1.526	1.527	1.526	1.526		
I	3.048	3.058		3.052	3.052	3.053	3.052		
J	4.575	4.585		4.579	4.578	4.579	4.579		
K	0.315	0.322		0.320	0.320	0.320	0.320		
L	0.495	0.505		0.502	0.501	0.502	0.501		
M	0.490	0.510		0.500	0.502	0.503	0.501		
N	1.615	1.635		1.629	1.630	1.629	1.629		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.252	2.253	2.253		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.497	0.498	0.498	0.498		
T	1.375	1.395		1.387	1.394	1.387	1.388		
U	2.000	2.020		2.000	2.010	2.005	2.005		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

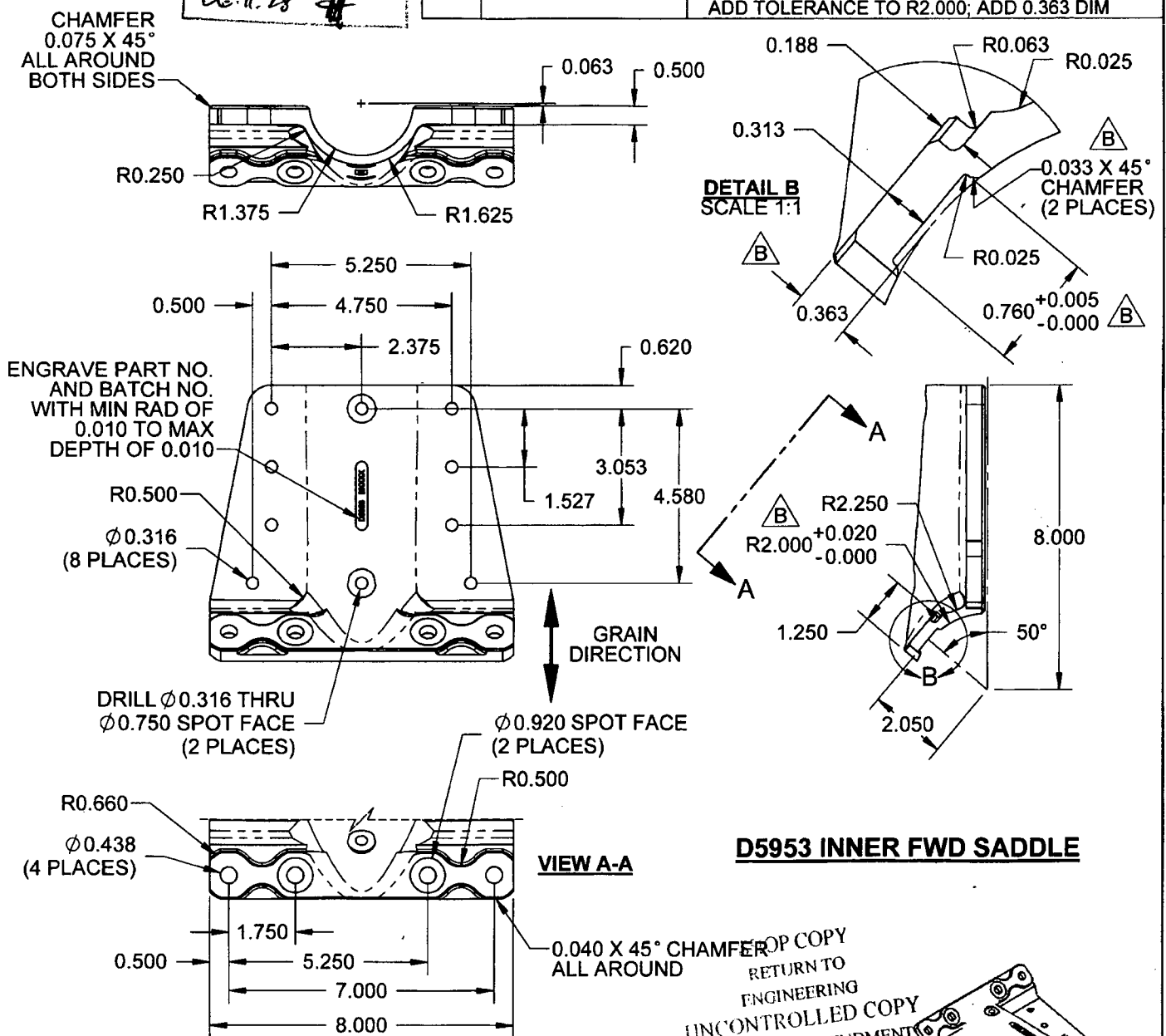
Measured by:	N.A
Date:	09/05/05

Audited by:	[Signature]
Date:	09/05/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	[Signature]

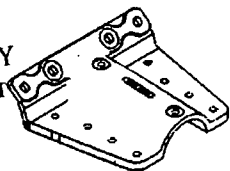
**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>CE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5953</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>INNER FWD SADDLE</b> SCALE 1:4		
REV	DATE	DESCRIPTION	
A	97.05.06	NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 421031



**ISOMETRIC VIEW**  
SCALE 1:8

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